



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200
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D5565-041
Job Sheet 186784



Part No: D5565-041

Job Qty: 4 pcs

Part Name: EC135/145 OEM Wearplate Assy - Float Skid AFT, LH/RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/21/18

Job Tracking No:

Due Date: 12/20/18

Created By: Jesse White

Type: ~~Stock~~

Description: SIOP

Note: D5565 REV.B IPP REV:A 17.11.27 NEW ISSUE DD VERF:JFS IPP REV:B 18.05.02 AS PER DWG REV:A-
PRELIM DD VERF:JFS IPP REV:C 18/07/31 AS PER DWG REV:B JFS VERIFIED BY:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Automated Welding - 1	4 pcs		12/20/18	0.00	1.00	Automated Welding - 1		ER
110	QC 10	4 pcs		12/20/18	0.00	0.00	QC 10 - 10		
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 38		
							QC 10 - 43		
							QC 10 - 50		
							QC 10 - 58		
							QC 10 - 9		
120	Large Fab - Welded Assy-2-B4B	4 pcs		12/20/18	0.00	1.33	Large Fab - 1 - B4B		JBC
							Large Fab - 10 - B4B		
							Large Fab - 2 - B4B		
							Large Fab - 3 - B4B		
							Large Fab - 4 - B4B		
							Large Fab - 5 - B4B		
							Large Fab - 6 - B4B		
							Large Fab - 7 - B4B		
							Large Fab - 8 - B4B		
							Large Fab - 9 - B4B		
130	QC 9	4 pcs		12/20/18	0.00	0.00	QC 9 - 10		ER
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
140	QC 5	4 pcs		12/20/18	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		

				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		
				QC 5 - 38		
				QC 5 - 42		
				QC 5 - 43		
				QC 5 - 49		
				QC 5 - 51		
				QC 5 - 58		
				QC 5 - 68		
				QC 5 - 9		
				QC 5 - 50	GA	
				QC 5 - 30		
150	Spray Paint - 2 - B4B	4 pcs	12/20/18	0.00 1.00	Spray Paint - 1 - B4B	• AQ 19-2-10
					Spray Paint - 2 - B4B	
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
160	QC 3	4 pcs	12/20/18	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 26	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 38	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 6	DAS
					QC 3 - 68	40
					QC 3 - 9	9-89
170	Packaging 3-1 - Stock - B4B	4 pcs	12/20/18	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Plex 1/25/19 12:06 PM Dart.Hadley.Shannon	

19.02.20

				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	4 pcs	12/20/18	0.00 0.00	QC 21 - SA - 21	DAC FEB 2 0 2019
				QC 21 - SA - 70	21 FEB 2 1 2019
Part Op 100 - (Automated welding) Weld hardfacing as per dwg. Hardcoat 8259 Batch: _____ Descriptions: 110 - (QC10- Inspect visual per QSI004- ground welds) 120 - (Weld per dwg A/R S.S. rod Batch: _____) WELD SPACERS TO WEARPLATE AS PER DWG 130 - (QC9- Inspect visual per QSI004- Fusion Welds) 140 - (QC5- Inspect part completeness to step on W/O) ***INSPECT WEARPLATE FIT TO SKIDTUBE IN BACK SHED*** 150 - (Spray Paint / NDT Room) APPLY TEXTURE COATING ON CONCAVE SURFACE AS PER DWG AND NOTE9 TEXTURE COATING BATCH: <u>5147896</u> 160 - (QC3- Inspect Part Finish) 170 - (Identify as per dwg & Stock Location: _____) 180 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D5565-1	Wearplate	4 pcs (1 ea)	100-Automated Welding - 1	S131238	
D5564-3	Middle Spacer	4 pcs (1 ea)	120-Large Fab - Welded Assy-2- B4B	S131508	
D5564-5	Spacer	8 Ea (2 ea)	120-Large Fab - Welded Assy-2- B4B	2-S107536, 6-S107562	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Automated Welding - 1	D5565-1	4	8	0	
120-Large Fab - Welded Assy-2- B4B	D5564-3	4	49	0	
	D5564-5	8	40	0	

Part Specifications
Specifications could not be found.

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Type: Stock

Description: SIOP

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Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		12/20/18	0.00	0.00	Start Up Large Fab-7		
100	Autoweld 1	4 pcs		12/20/18	0.00	1.00	Automated welding		
110	QC	4 pcs		12/20/18	0.00	0.00	QC10		
120	Large Fab	4 pcs		12/20/18	0.00	1.33	Large Fab 1		
130	QC	4 pcs		12/20/18	0.00	0.00	QC9		
140	QC	4 pcs		12/20/18	0.00	0.00	QC5		
150	SprayPaint	4 pcs		12/20/18	0.00	1.00	Spray Paint		
160	QC	4 pcs		12/20/18	0.00	0.00	QC3		
170	Packaging	4 pcs		12/20/18	0.00	0.00	Packaging3 Large Fab		
180	QC21-SA	4 Ea		12/20/18	0.00	0.00	QC21		

Part Op 100 - Weld hardfacing as per dwg. Hardcoat 8259 Batch: _____

Descriptions: 120 - WELD SPACERS TO WEARPLATE AS PER DWG

140 - ***INSPECT WEARPLATE FIT TO SKIDTUBE IN BACK SHED***

150 - APPLY TEXTURE COATING ON CONCAVE SURFACE AS PER DWG AND NOTE9 TEXTURE COATING
BATCH: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D5565-1	Wearplate	4 Ea (1 ea)	90-Start up Operation	
D5564-3	Middle Spacer	4 Ea (1 ea)	120-Large Fab	
D5564-5	Spacer	8 Ea (2 ea)	120-Large Fab	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D5565-1	4	0	0
120-Large Fab	D5564-3	4	29	0
	D5564-5	8	20	0

Part Specifications

Specifications could not be found.

Plex 11/21/18 10:40 AM dart.white.jesse



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Container No: S151466



Part: D5565-041

Job No: 186784

Serial No/Batch: S151466

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/06/19